

Work Order ID 63018

Monday, October 18, 2010 8:55:34 AM



Page 1

Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Item Name: Crosstube Aft

Stop



Start Date: 10/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-10-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-664-243	E

100		0.00
-----	--	------



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

8 10/11/24

HJ for BG 10-11-23

110		0.00
-----	--	------



Packaging

Packaging

Memo

0.00

Packaging

N/A

10.11.26

120		0.00
-----	--	------



CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010

DP 10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 10/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

CP 10.11.02

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

SAD
10-11-03

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00

Customer:






Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo	0.00 0.00							
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

SAD
10-11-04SAD
10-11-04SAD
10-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Outsource process - NDT per QSI038 4.1

0.00

Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 12912 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work orderCL 10/11/12 (1)

190

Packaging

0.00

Packaging

Memo

0.00

Packaging

Inspect for transit damage
Ensure copy of NDT results attached to work order.CL 10/14/12 (1)

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Inspect for damage & ensure results are as per Dwg D412-664-203

ml 10 11 15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 10/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2 PRIME: Start Time: <u>8:00</u> Finish Time: <u>9:00</u> PAINT: Start Time: <u>1:30</u> Finish Time: <u>2:30</u>								
220		0.00							
	QC14- Inspect Spray Paint								
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								

m 10 11 16 (1)

45 10-15-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D412-664-203

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 10/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



Crosstubes

Crosstubes

Crosstubes

Memo

Assemble as per Dwg D412-664-203

0.00

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch: 115580

Expiry Date: 07/2011

3-Install clamps as per Dwg D212-664-203 using installation jig DT9024 with 0.010 thick brass shims on both chafing shield (D3189-1). Torque clamps to 80-100 in lb. ml 10 11 23 ①

ml 10 11 22 ①

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80/4/23

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 63018

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Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 10/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/24

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/24

ⓧ

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-203
*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27
for application time & date *****
Time & date of packaging: 10/11/24
Location: 103

ReoH

10/11/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 63018

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Item ID: D412-664-203

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Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 10/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/25 *[Signature]*
MF
10-11-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 8:55:39 AM

Page 1

Work Order ID: 63018

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft



Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.16 Reformat; Added D3189-1 K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-664-203TRN Manufactured No



Crosstube Turning Detail

110 Each 2.0000



1

SAD 10-10-28

Location	Loc Qty	Loc Code
----------	---------	----------

LG	2	
62500	1	
62501	1	

D2856-600 Manufactured No



Abrasion Strip

230 f 160.9891



1.76

1.76

ml 10-11-22

Location	Loc Qty	Loc Code
----------	---------	----------

ST	0.48	
37668	0.48	
ST403	160.5091	
25656	1.25	
26650	2.5	
37668	156.7591	

D2896-1 Manufactured No



Support

230 Each 19.0000



1

1

ml 10-11-22

Location	Loc Qty	Loc Code
----------	---------	----------

LG	19	
47820	11	
58356	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 63018

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3189-1
Chafing Shield

Manufactured No

230 Each

22.0000

2 2

ml 10-11-22

Location

Loc Qty

Loc Code

FG

2

36065

2

LG

20

58960

20

D3595-063-570

Manufactured No

230 Each

4.0000

2 2

ml 10-11-22

RUBBER CUSHION

B#42243

Location

Loc Qty

Loc Code

FG

4

37971

4

MS21920-28

Purchased No

230 Each

57.0000

4 4

ml 10-11-22

Clamp(per MIL-DTL-8783C)

114749

Location

Loc Qty

Loc Code

FG

5

105884

5

LG

52

112863

4

114749

48

MS21920-30

Purchased No

230 Each

106.0000

2 2

ml 10-11-22

clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

106

109181

36

111258

50

112772

20

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 63018

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

250

Each

107.0000

4

4

Bolt

Location

Loc Qty

Loc Code

ST343

107

112828

1

114283

26

115300

60

115905

20

AN6-41A

Purchased

No

250

Each

62.0000

2

2

Bolt

Location

Loc Qty

Loc Code

ST344

62

113288

32

115316

30

AN960JD616

NAS1149D0663J

Purchased

No

250

Each

0.0000

18

18

Washer

MS21042L6

Purchased

No

250

Each

227.0000

6

6

Nut

Location

Loc Qty

Loc Code

ST300

227

111578

4

114495

23

115300

200

Monday, October 18, 2010 8:55:39 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

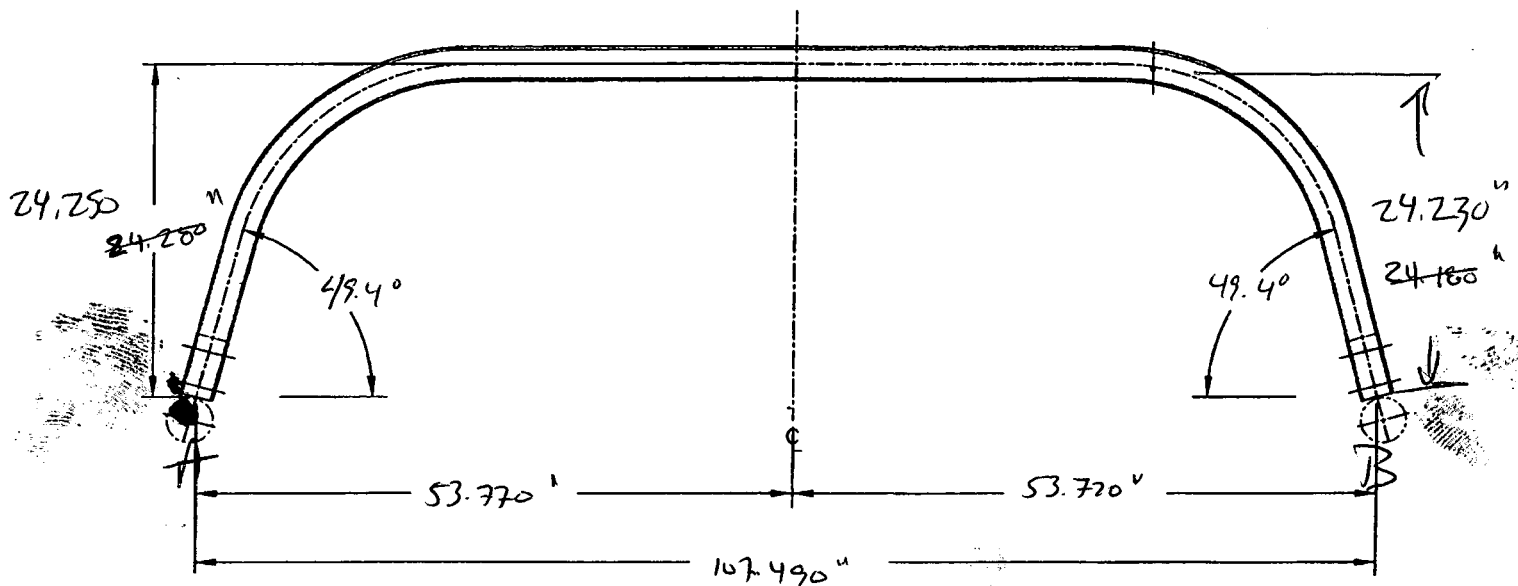
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63018
Description: Crosstube High Aft (412)		Part Number: D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Tube low on one side by 0.070"
Acceptable
JP 10.11.02

QC15 Inspection	JP
Date	10.11.02

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	

53.770
53.720
107.490

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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P. 1000 TO
COPY
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NO. 63015
P/O 10-18

RELEASED
2009-10-29

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. E
MFG. APPR.	IS	D412-664-243	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

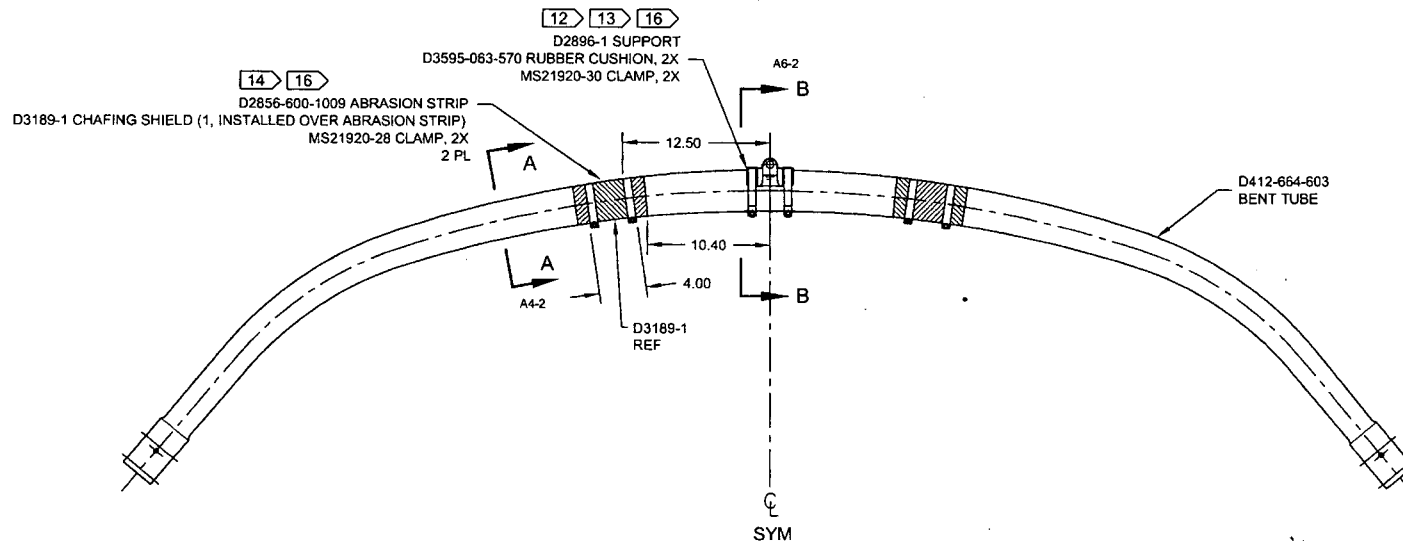
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

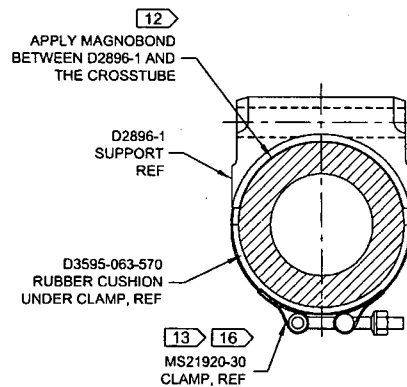
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

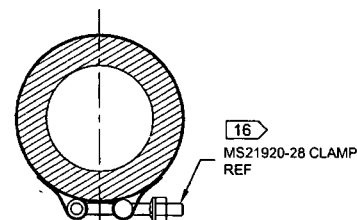
NOTE: Date & initial all entries



D212-664-243
ASSEMBLY DETAIL



SECTION B-B D4-2
SCALE 4X



SECTION A-A C6-2
SCALE 4X

wlo 63018

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2009-10-29
NMP

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>Q</i>	D412-664-243	SHEET 2 OF 4
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

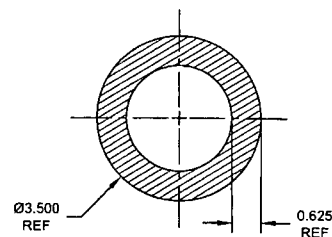
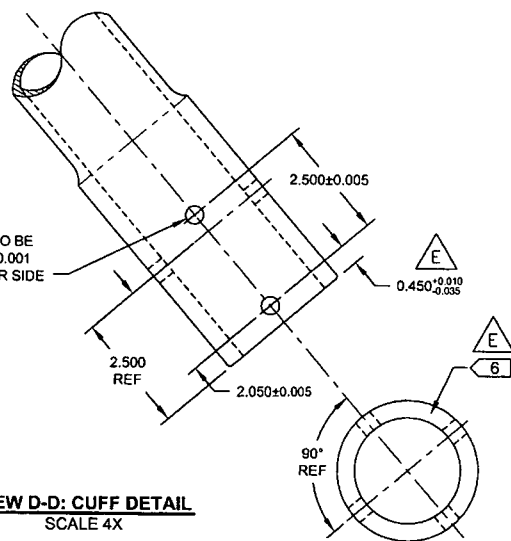
D412-664-603 10
BENDING AND DRILLING DETAIL E

w/63018

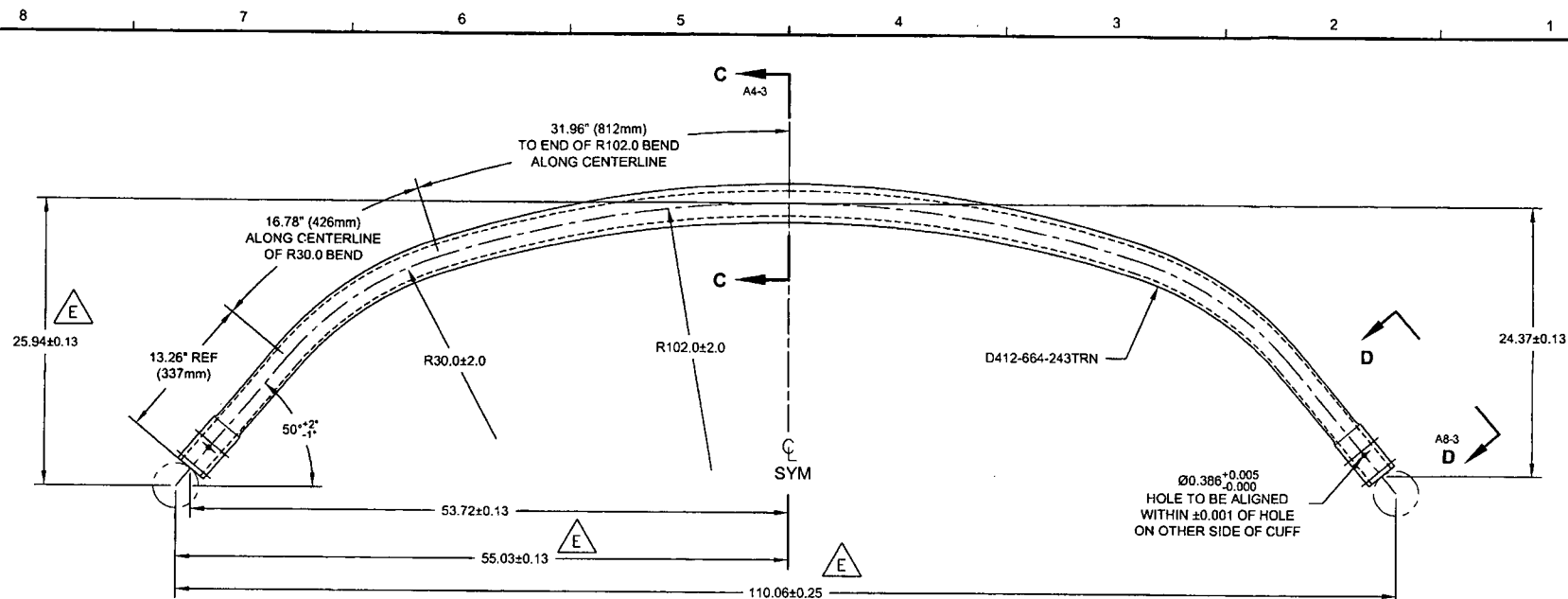
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 2009-10-29
MP

Ø0.386^{+0.005}_{-0.000} HOLE TO BE
 ALIGNED WITHIN ±0.001
 OF HOLE ON OTHER SIDE
 OF CUFF
 2 PL

VIEW D-D: CUFF DETAIL
 SCALE 4X



SECTION C-C
 SCALE 4X



DESIGN	<i>PH</i>	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>Q</i>	DRAWING NO. REV. E
MFG. APPR.	<i>PS</i>	D412-664-243 SHEET 3 OF 4
APPROVED	<i>MP</i>	TITLE SCALE
DE APPR.	<i>MP</i>	CROSSTUBE ASSEMBLY (412 HI AFT) NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD
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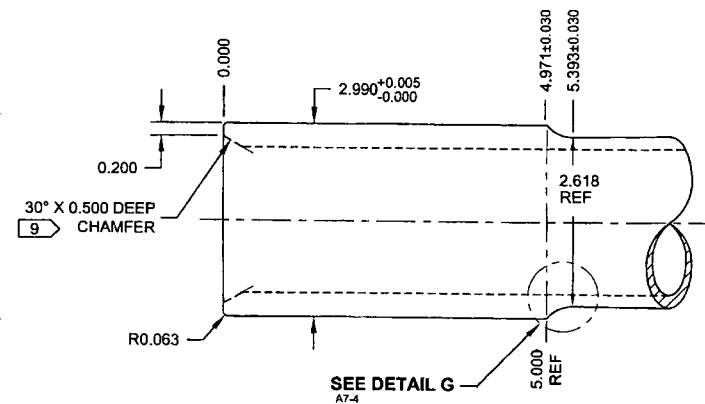
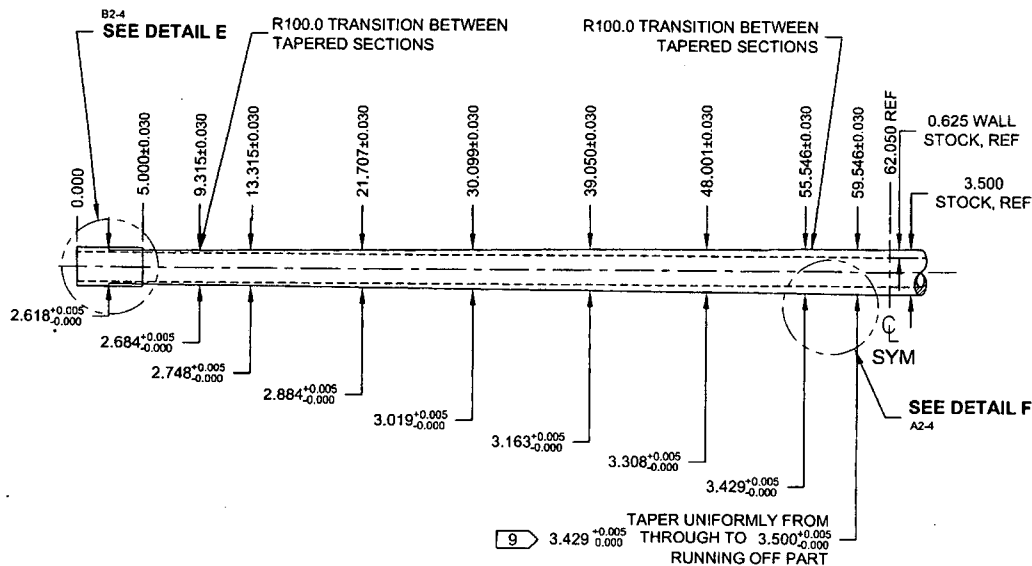
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

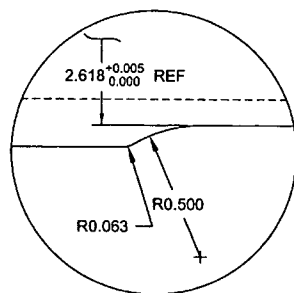
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

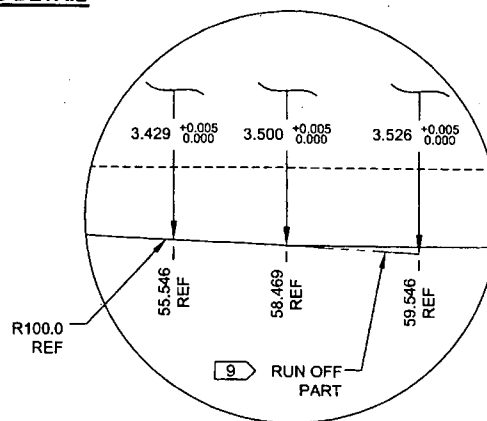


DETAIL E:
CROSSTUBE CUFF D8-4
SCALE 5X

D412-664-243TRN
TURNING DETAIL E



DETAIL G:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL F:
TAPER RUN-OFF C4-4
NOT TO SCALE

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2009-10-29
MMP

DESIGN	PH	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	92	DRAWING NO. REV. E
MFG. APPR.	SS	D412-664-243 SHEET 4 OF 4
APPROVED	140	TITLE SCALE
DE APPR.	14	CROSSTUBE ASSEMBLY (412 HI AFT) NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15198

PAGE 1 OF 1

CLIENT DART Aero Space DATE Nov. 12. 2010 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-10-0937
ADDRESS 1270 ABELDEEN ST. PO/VO NO. 12912
HAWKES BURY, ON. WORK LOCATION HAWKES BURY PLANT.
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON CROSS TUBES.
ITEM(S) EXAMINED 8 UNITS.

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE 2008 TECHNIQUE NO. LT-TECH2 REV./DATE 2008
PART NO. CROSS TUBES - SEE RESULTS MATERIAL ALUMINUM THICKNESS —
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL SURFACE.

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/CM² ☐ AMBIENT < 2 fc
PENETRANT ZL67 MINIMUM DWELL TIME 1045 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY 067-19-2011

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1	CROSS TUBE : W.O. 62923	✓
1	CROSS TUBE : W.O. 62924	✓
1	CROSS TUBE : W.O. 62746	✓
1	CROSS TUBE : W.O. 62745	✓
1	CROSS TUBE : W.O. 63019	✓
1	CROSS TUBE : W.O. 63618	✓
1	CROSS TUBE : W.O. 62190	✓
1	CROSS TUBE : W.O. 62189	✓

MA 10-11-15

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>MAH MURDOGH</u>	<u>MAH MURDOGH</u> SIGNATURE	DTR # <u>E03234</u>
TECHNICIAN (SIGNATURE): <u>Mike Thorsen</u>		REPORT REVIEWED BY:
NAME (PRINT): <u>Mike Thorsen</u>	1 ST TECHNICIAN	NAME INITIALS
CGSB LEVEL <u>2</u> SNT LEVEL	CGSB LEVEL SNT LEVEL	
CGSB REG. NO <u>6606</u>	CGSB REG. NO	

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	-101	-201	-203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
31			2	* D2856-600-1009	ABRASION STRIP
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			*2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AA
SKIDTUBES.